

Date: 01/08/2008 3:28:44 PM
 User: Julie Lecocq

Process Sheet

SPLIT-1

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: MOUNTING LUG
Job Number	: 40934		
Estimate Number	: 10255		
P.O. Number	:	Part Number	: D22301
This Issue	: 01/08/2008 S.O. No. :	Drawing Number	: D2230 REV F
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: 1/	Drawing Revision	: F
Previous Run	: 39315	Material	:
	Type : MACHINED PARTS	Due Date	: 15/08/2008
Written By	:	Qty:	200 Um: Each
Checked & Approved By	: <u>JLP 08.8.05</u>		
Comment	: Est D 00.11.01 Added inspection level 8, and removed P/O for powder coat EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	D2423	Lug Extrusion
-----	-------	---------------



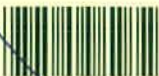
Comment: Qty.: 0.0717 f(s)/Unit Total: 14.3430 f(s)
 Lug Extrusion D2423 Extrusion
 Batch: B33310

2.0	BAND SAW	BAND SAW
-----	----------	----------



Comment: BAND SAW
 Cut D2423 extrusion to 0.82"
 Batch: 1

3.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
-----	-------	--------------------------------



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine per folio D2230-1
 (Check for crack while loading into the machine.)
 2-Tumble and deburr rough edges after tumbling

machine pending
D2230 REV. F

08/08/06
200

4.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
-----	-----	--



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

5.0	QC2	SECOND CHECK
-----	-----	--------------



Comment: SECOND CHECK

08/08/25
200

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 01/08/2008 3:28:44 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: MOUNTING LUG

Job Number: 40934

Part Number: D22301

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

m-l

08/08/27 (X90)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S *08/08/27* (X90)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat Gloss White (ref. 4.3.5.1) per Dart QSI 005 4.3

M108523

(90X)

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

10:30
320
11:00

m-l *08/08/27*

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

92

08-08-27 (X90)

10.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST476

SS *08/08/27* *-80 RNNILK*

X90

11.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/08/27

Job Completion



MF 08-08-28

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

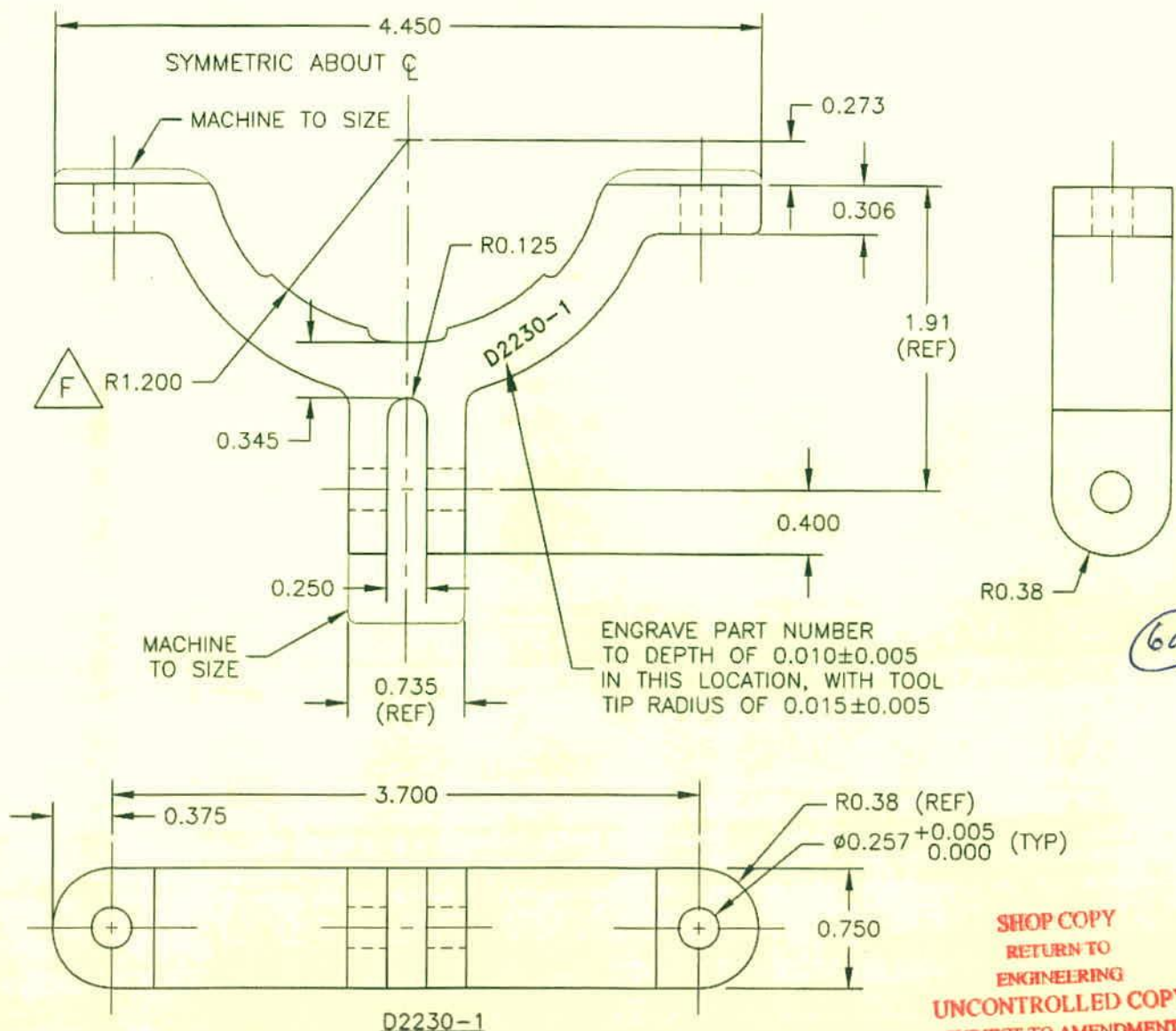
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART

DESIGN	<i>CP</i>	DRAWN BY	<i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	<i>#</i>	APPROVED	<i>#</i>	DRAWING NO. D2230 REV. F SHEET 1 OF 2
DATE	99.12.13	TITLE	MOUNTING LUG	SCALE 1:1
C	94.03.30	RE-DESIGN		
D	95.01.04	RE-DESIGN		
E	95.01.04	RE-DESIGN		
F	99.12.13	REDESIGN; R1.200 WAS R1.100		

RELEASED
99.12.21 DS

MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

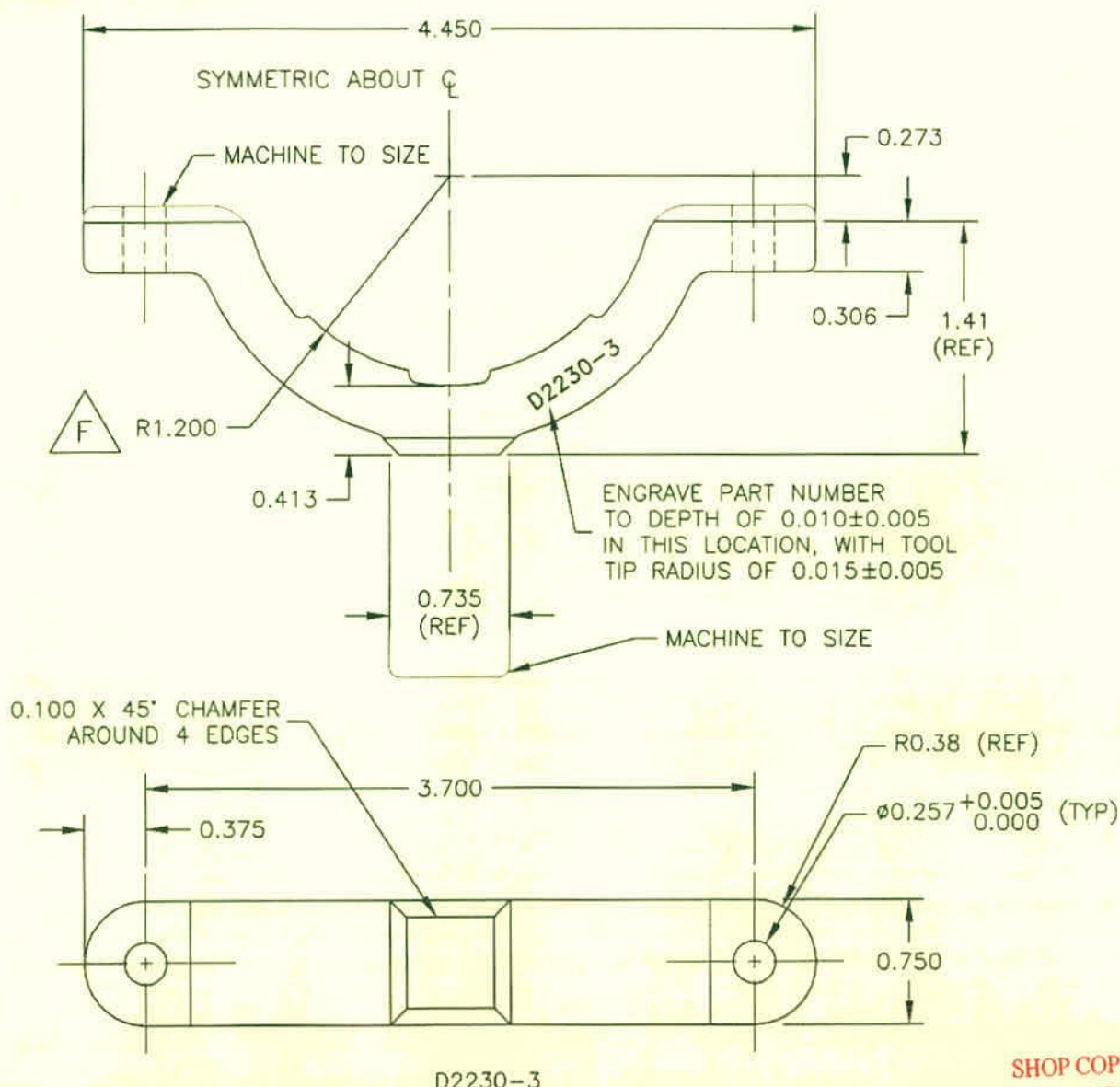
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40939

224-444 21500-10



DESIGN CP	DRAWN BY CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED [Signature]	APPROVED [Signature]	DRAWING NO. D2230	REV. F SHEET 2 OF 2
DATE 99.12.13		TITLE MOUNTING LUG	SCALE 1:1

RELEASED
99.12.21 DS



MAKE FROM EXTRUSION D2423
BREAK ALL EDGES 0.000-0.015
FINISH: ACID ETCH AND ALODINE PER DART QSI 005 4.1
POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 40934

11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11

11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11

11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11
 11 11 11 11 11

11 11 11 11 11



CERTIFICATE OF CONFORMITY

SOLD TO:

Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, Ont.
K6A 1K7

SHIPPED TO:

same

QUANTITY

PART NUMBER

PART NAME

P.O. NUMBER

90

D2230-1

Lug B40934

6881

08/08/08

MATERIAL: supplied by DART D2423 B33310

We hereby certify that the above parts were made in conformance with applicable drawings.

METEC Metal Technology Inc.

Shig Walz
Shig Walz

Vankleek Hill, August 25, 2008

